

Date: Monday, 12/01/2009 2:36:33 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACER
Job Number :	44643		
Estimate Number :	12489		
P.O. Number :		Part Number :	D35321
This Issue :	12/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3532 REV.A
First Issue :	/ /	Project Number :	N/A
Previous Run :	42350	Drawing Revision :	REV.A
	Type :	Material :	
	MACHINED PARTS	Due Date :	30/01/2009
Written By :		Qty:	30
Checked & Approved By :	<u>JLD 09.01.13</u>	Um:	Each
Comment :	Est Rev:A New Issue 06-07-12 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	MDELNR0750	Delrin Round Bar 0.75"
-----	------------	------------------------



Comment: Qty.: 0.0326 f(s)/Unit Total : 0.9765 f(s)
 Delrin round bar 0.750 dia.
 (MDELNR0750)
 Batch: M109571

mk 09/01/18

(34)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL
 1-TURN AS PER FOLIO FA643 & DWG D3532 ,
 FOLIO REV: AA
 DWG REV: A

2-DEBURR AS REQUIRED

mk 09/01/18

(34)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 09/01/18

34

4.0	QC8	SECOND CHECK
-----	-----	--------------

Comment: SECOND CHECK

mk 09/01/18

(34)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: ST 107

mk 09/01/20 (34)

Page 1

Form: rprocess

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:36:33 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 44643

Part Number: D35321

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/21/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 9.26.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

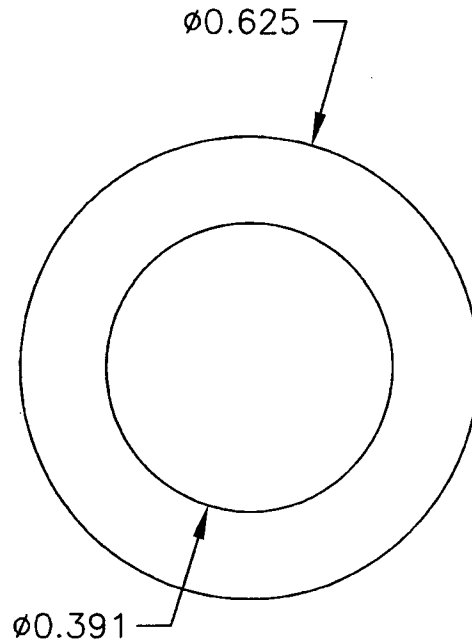
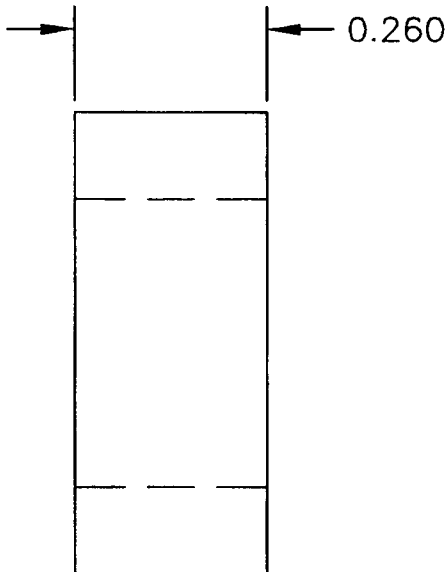
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3532	REV. A SHEET 1 OF 1
DATE 06.06.26		TITLE SPACER	SCALE 4:1
A	06.06.26	NEW ISSUE	



D3532-1 SPACER

D3532-1 SPACER

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-RD.DDD)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 441043

RELEASED
06-06-26

Copyright © 2006 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.